Item ID:	D3719-041		Accept			Setup	Start	
Revision ID:								
Item Name:	Wearplate						Stop	

| Start Date: | 11/11/2010 | Start Qty: | 5.00 | | Cust Item ID: |
| Required Date: | 11/18/2010 | Req'd Qty: | 5.00 | | Customer: |

Reference:

			Run	Start	
Approvals:	Process Plan: _____	Date: *10-11-11*	Tooling: _____	Date:_____	Run	Stop	
	QC: _____	Date:_____	SPC (Y/N): _____	Date:_____			

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3719	Rev A								
100		0.00							
Waterjet	FLOW WATER JET								
	Memo	0.00						*B 10-11-17*	
FLOW CNC Waterjet	1-Cut as per Dwg D3719 □Dwg Rev:_*B*_ □Prog Rev:_*A*_ □2-								⑤
304. 663	Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00						*B 10-11-17*	
Quality Control									
120	QC8- Inspect parts - second check	0.00 *₰ 10/14/18*							
QC	Memo	0.00							*(J)*
Quality Control									

Dart Aerospace Ltd

WORK ORDER CHANGES

W/O:							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:			Corrective Action	Section B				
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Item ID:	D3719-041	**Accept**		**Setup Start**
Revision ID:				**Stop**
Item Name:	Wearplate			
Start Date:	11/11/2010 **Start Qty:** 5.00		**Cust Item ID:**	
Required Date:	11/18/2010 **Req'd Qty:** 5.00		**Customer:**	
Reference:				

Run   Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
Large Fab	Large Fab							EL 10-11-30	(X 5)
Large Fab	Memo	0.00							
	1-Weld D3009-3 cups as per dwg D3719☐2-Weld hard facing as per Dwg D3719 ☐A/R 2059B Hard Coat rod Batch: *M 116 044* -								
140	QC9- Inspect visual per QSI004- Fusion Welds	0.00	*Qpl 10·11·30*						
QC	Memo	0.00							
Quality Control									
150	QC5- Inspect part completeness to step on W/O	0.00	*Dowbo*					(X J)	
QC	Memo	0.00							
Quality Control									

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W/O:		WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

　　Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action**　Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Item ID:	D3719-041		Accept		Setup	Start
Revision ID:						Stop
Item Name:	Wearplate					

Start Date:	11/11/2010	Start Qty: 5.00		Cust Item ID:	
Required Date:	11/18/2010	Req'd Qty: 5.00		Customer:	
Reference:					

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Grey Sandtex(Ref.4.3.5.6) per QS1005 4.3	0.00				5		*M N2588*	*RK 10-12-6*
Powdercoat	Memo	0.00							
Powder Coating	START TIME: *10.00* FINISH TIME: *10.50* OVEN TEMPERATURE: *300*								
170	QC3- Inspect Part Finish	0.00				5	0	*2) M 10/12/06*	
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: *501*	0.00				*10/12/6*			
Packaging	Memo	0.00							
Packaging									

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Item ID:	D3719-041		Accept		Setup	Start	
Revision ID:							
Item Name:	Wearplate					Stop	

Start Date:	11/11/2010	Start Qty: 5.00		Cust Item ID:			
Required Date:	11/18/2010	Req'd Qty: 5.00		Customer:			
Reference:							

| Approvals: | Process Plan: _____ | Date: _____ | Tooling: _____ | Date: _____ | Run | Start | |
| | QC: _____ | Date: _____ | SPC (Y/N): _____ | Date: _____ | | Stop | |

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							10/12/07
QC	Memo	0.00							
Quality Control									

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Dart Aerospace Ltd

WORK ORDER CHANGES

W/O:							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:			Corrective Action	Section B				
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID: 63725

Parent Item: D3719-041

Parent Item Name: Wear..ate

Start Date: 11/11/2010   **Required Date:** 11/18/2010

Start Qty: 5.00   **Required Qty:** 5.00

Comments: IPP Rev :A New Issue 07-12-19 EC verified by DD
IPP Rev:B 08-09-25 add QC5 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3009-3		Manufactured	No			100	Each	185.0000	4	20			
Cup													

Location	Loc Qty	Loc Code
WA	185	
42377	185	

EC 10-11-30

20

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			130	sf	166.3000	0.565	2.973684			
304/316 Sheet .063													

LB 10-11-17

Location	Loc Qty	Loc Code
MAT	166.3	
111323	0	
115688	6.3	
115953	160	

⑤

115953

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	43725
Description: Wearplate		Part Number:	D3719-1
Inspection Dwg: D3719 Rev: A			Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] **First Article**   [ ] **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.879	+0.010/-0.001	.881	✗		V 1302	
0.750	+/-0.010	.754	✗		V	
4.582	+/-0.010	4.582	✗		V	
3.0..	+/-0.030	3.009	✗		V	
6.08	+/-0.030	6.072	✓		V	
1.80	+/-0.030	1.80	✗		V	
10.290	+/-0.010	10.289	✗		V PRO1302	
13.54	+/-0.030	13.540	✗		T 1301	
0.063	+/-0.010	.058	✗		V	

Measured by: 13	Audited by:	Prototype Approval:	N/A
Date: 10-11-17	Date: 10/11/18	Date:	N/A

Rev	Date	Change		Revised by	Approved
A	08.10.07	New Issue	P/O D3719-041	KJ/DD	

Dart Aerospace Ltd

WORK ORDER CHANGES

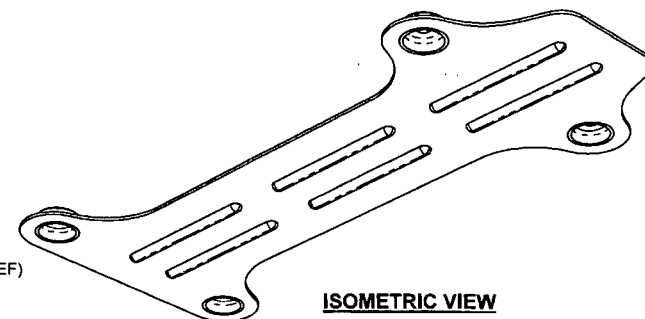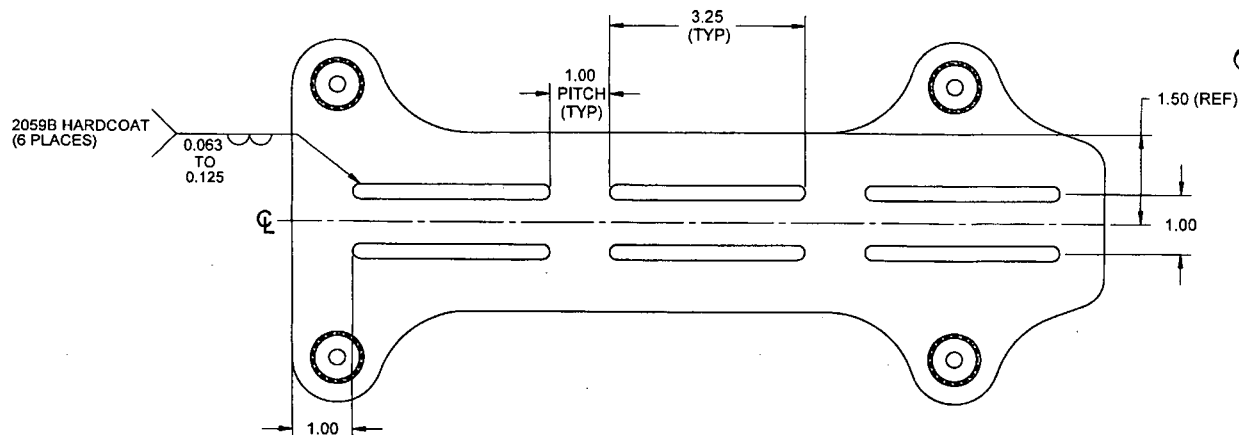| W/O:							
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:			Corrective Action	Section B				
DATE	**STEP**	**Description of NC** Section A	**Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector

NOTE: Date & initial all entries

PARTS LIST FOR D3719-041 WEARPLATE:

QTY.	PART NUMBER	DESCRIPTION
1	D3719-1	WEARPLATE
4	D3009-3	CUP

ISOMETRIC VIEW

2059B HARDCOAT
(6 PLACES)

0.063
TO
0.125

3.25
(TYP)

1.00
PITCH
(TYP)

1.50 (REF)

1.00

CL

1.00

HARDCOAT WELD
SURFACING (REF)

D3719-1 WEARPLATE

INSTALL D3009-3 (REF) FLUSH
WITH THIS SURFACE (TYP)

(4 PLACES)

1/32

6

D3009-3 CUP
(4 PLACES)
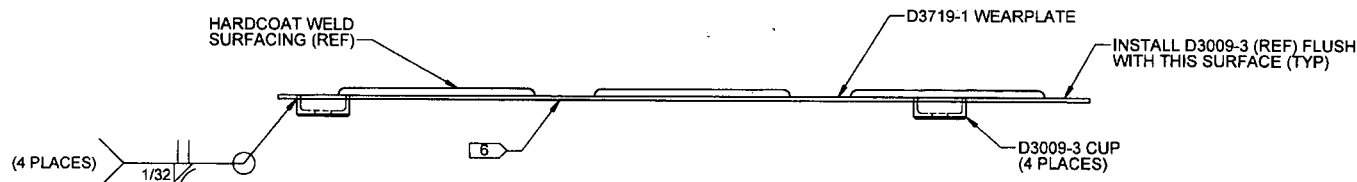
D3719-041 WEARPLATE

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3719-041" & B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 1.11 lbs
8) PART IS SYMMETRIC ABOUT CENTERLINE
9) WELD PER DART QSI 004

A	NEW ISSUE			CP	07.12.12
REV.		DESCRIPTION		BY	DATE

DESIGN		**DART AEROSPACE LTD**	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3719	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	1:2
DATE	07.12.12		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

R1.50
(TYP)

R0.50
(TYP)

1.50
(REF)

1.80

6.08
(REF)

3.00

4.582

C̵L̵

3.703

.434

Ø0.879
(4 PLACES)

70°

0.750

.310

9.441

10.290

13.54

R0.750
(TYP)

D3719-1 WEARPLATE

R1 10-11-11

RELEASED
08.01.07

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK)
           (REF DART SPEC M304S16GA)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.87 lbs
8) PART IS SYMMETRIC ABOUT CENTERLINE

DESIGN		**DART AEROSPACE LTD**	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3719	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	1:1
DATE 07.12.12		COPYRIGHT © 2007 BY DART AEROSPACE LTD	

Dart Aerospace Ltd

WORK ORDER CHANGES

W/O:								
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries